

Ship Oct. 25

Work Order ID 62586 -



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Monday, October 04, 2010 3:21:46 PM

Item ID: D206-628-022BL

Revision ID:

Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010 Start Qty: 4.00

Required Date: 10/29/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: MF

Date: 10-10-04 Tooling:

Accept



Setup

Start



Stop



QC:

Date: SPC (Y/N):

Date:

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
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100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

0.00

0.00

110



Pick Kit

Packaging

Packaging

Memo

Photocopy blue file and type labels as per PPP D206-628-022 CHG 003

S 10/10/28

HJ for BG 10-10-19

120



QC4- 100% Inspect kits for completeness

QC

Quality Control

Memo

0.00

0.00

S 10/10/28

(X2)

RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-022BL

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step RH, Blue

Stop



Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____ Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130

Operation
Description

Packaging

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D206-628-022

Location: WYPPP Rev: C

10/10/08 2 SL

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/28 J

Quality Control

MF
10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62586



Parent Item: D206-628-022BL



Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

Comments: IPP RevF: add D2724-042 DD 09.11.17 verified by:ec

Start Qty: 4.00

Start Qty: 4.00

Required Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A		Purchased	No				Each	168.0000	4	16	16	10/10/2013	Open

<u>Location</u>	<u>Loc Qty</u>	<u>Loc C</u>
ST357	152	
114752	1	
<u>115371</u>	150	

ST358 16
113359 16

Each 577.0000

ST338 112

107737 12

108868 60

111295 52

112905 12
114232 3

114292 32

114784 58

115108 76

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 62586



Parent Item: D206-628-022BL



Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

AN960JD416



NAS1149D0463J Purchased

No

Each

24.0000

12

48



11/10/2010 M115647SF

Washer

4
S+4

D2724-042



206L Step Assembly

2731-7



Mounting Lug

Manufactured

No

Location

ST300

Loc Qty

24

Loc Code

113288

24

Each

0.0000

1



362589 10/10/2010

16

Manufactured

No

Each

55.0000

4



16

B62590 10/10/2010

D2732-030



Rubber Cushion

S+4

Manufactured

No

Location

ST420

Loc Qty

16

Loc Code

60996

16

ST470

39

59202

15

61653

24

Each

0.0000

8



32

8 feet 10/10/2010

D3394-043



Lug Assembly

S+4

Manufactured

No

Each

31.0000

4



16

B62589 10/10/2010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D206-628-022BL



Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L4



Purchased No

Each 4,434.000

12 48



Nut

ed/10/19 Sy (4)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	4434	
113422	68	
114523	8	
114718	16	
114784	32	
115108	1310	48
115589	1900	
115621	1100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

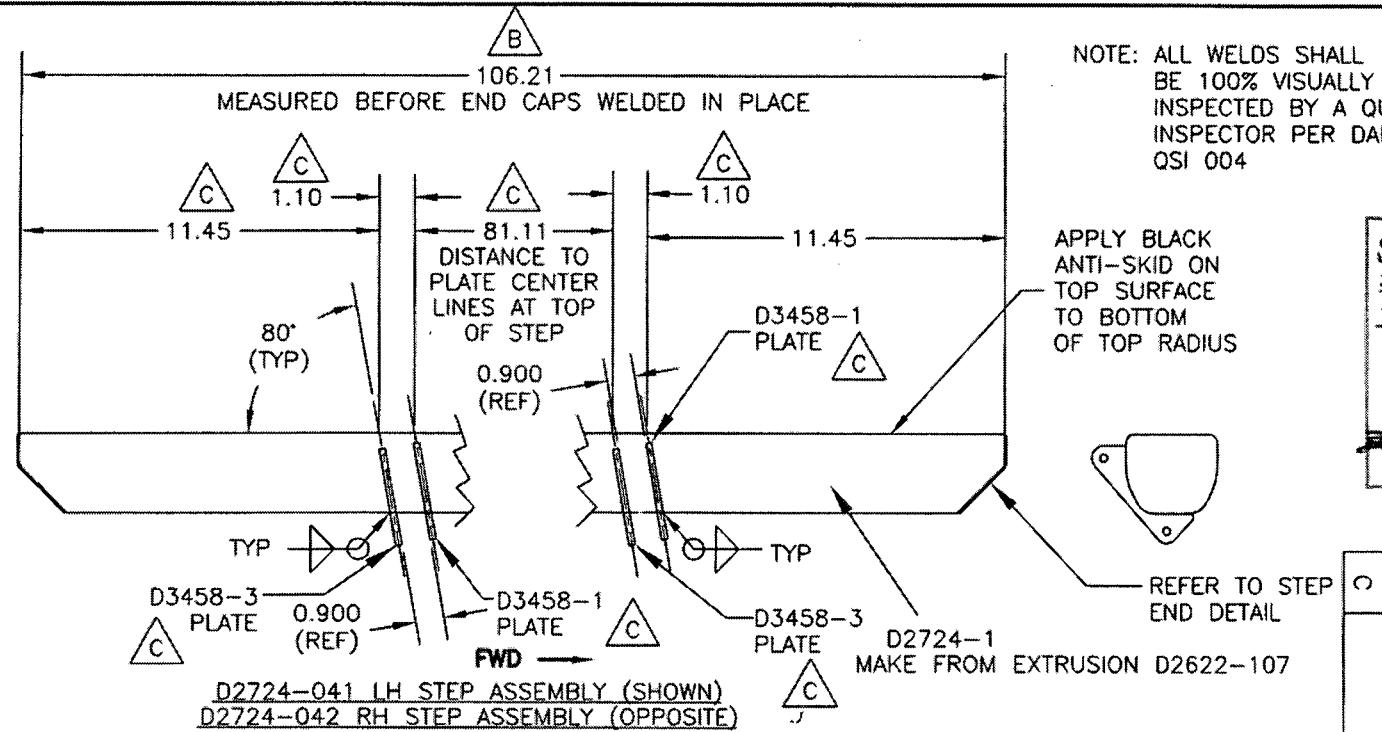
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS-
STEPS™ PARTS LIST**

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	/ NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE



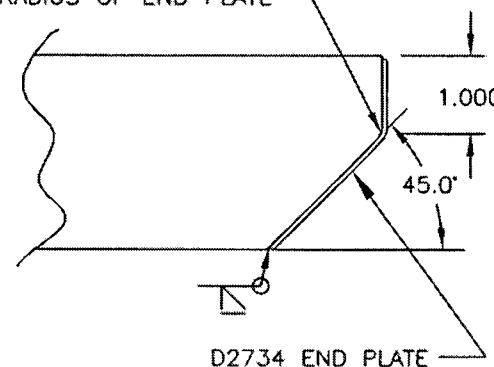
D2724-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
X		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D2724
DATE 05.09.19		TITLE 206L/407 STEP ASSEMBLY
A	97.12.04	REV. C SHEET 1 OF 1
B	98.10.19	SCALE NTS
C	05.09.19	RE-DESIGN, ADD D3458-1/-3